

Date: Friday, 07/12/2007 7:42:48 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 36172		Part Number	: D33155		
Estimate Number	: 10436		Drawing Number	: D3315 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 07/12/2007	S.O. No. :	Drawing Revision	: B		
Prsh Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 24/12/2007		
Previous Run	: 25727		Qty:	6	Um:	Each
Written By	: <u>L</u>					
Checked & Approved By	:					
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 1.9262 sf(s)/Unit Total: 11.5574 sf(s) 1010/1025/A21/6aA SHEET .060" THK (BATCH: 105706) HB 07-12-10
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3315 Dwg Rev: <u>B</u> HB 07-12-10 Prog Rev: <u>B</u> 6
		2-Deburr if necessary HB 07-12-10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE (B) 07-12-10
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 5 07-12-10 XG count
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u> SB 08/01/11 2- Form using DT8179 Die as per Dwg D3315 Rev: <u>B</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 7:42:48 AM
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Drawing Name: WEARPLATE

Job Number: 36172

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC6 DIMENSIONAL CHECK



8/08/08/11 6

Comment: DIMENSIONAL CHECK

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: 3

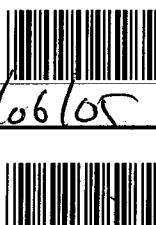
Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod m107553

8/08/08/05 6

8.0 QC10 +5 VISUAL WELDING INSPECTION

8/08/08/24



30 min

Comment: VISUAL WELDING INSPECTION

9.0 POWDER COATING POWDER COATING



09/06/2008

M 105642

S.296

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

#3 33671

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



#2 33671

Comment: INSPECT POWDER COAT

#3 33671

11.0 PACKAGING 1 PACKAGING RESOURCE #1



#4 33671

Comment: PACKAGING RESOURCE #1

#5 33671

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-5, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 495

8/06/09

SP

12.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/10 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/08/08/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

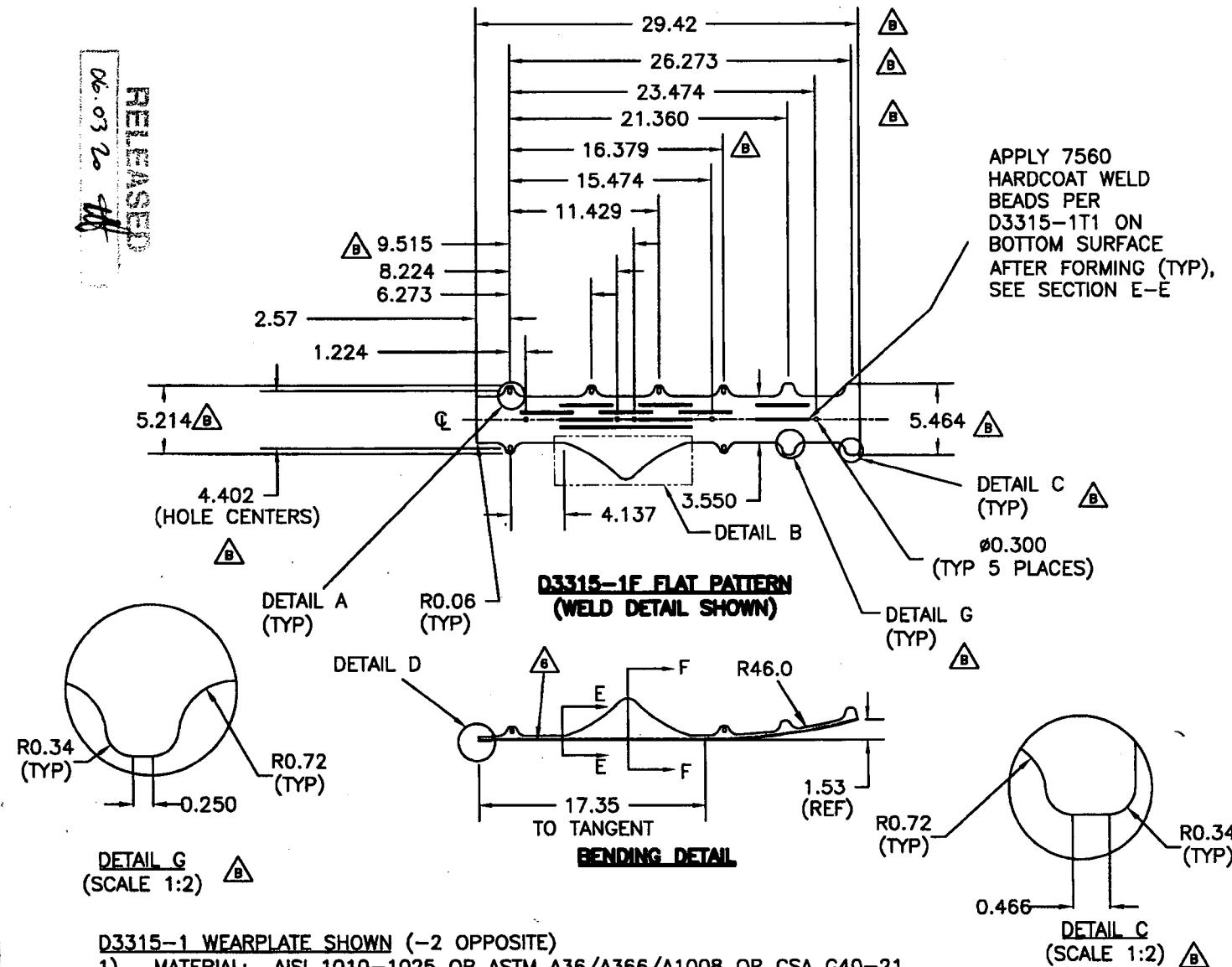
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE 06.01.31		TITLE D3315	REV. B
A 04.09.10	B 06.01.31	WEARPLATE	SHEET 1 OF 4
		UPDATE DIMENSIONS	SCALE 1:12

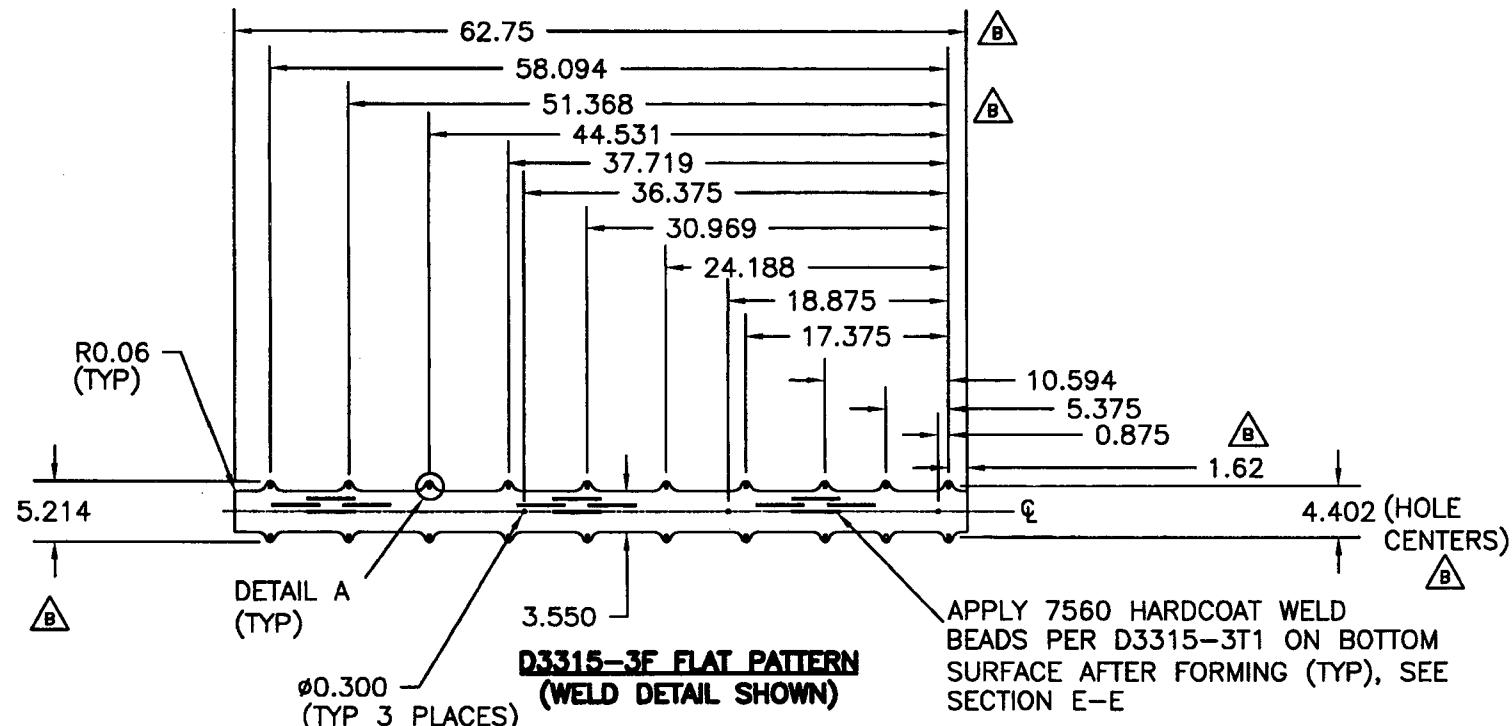
**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED

06.03.20 *[Signature]*



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

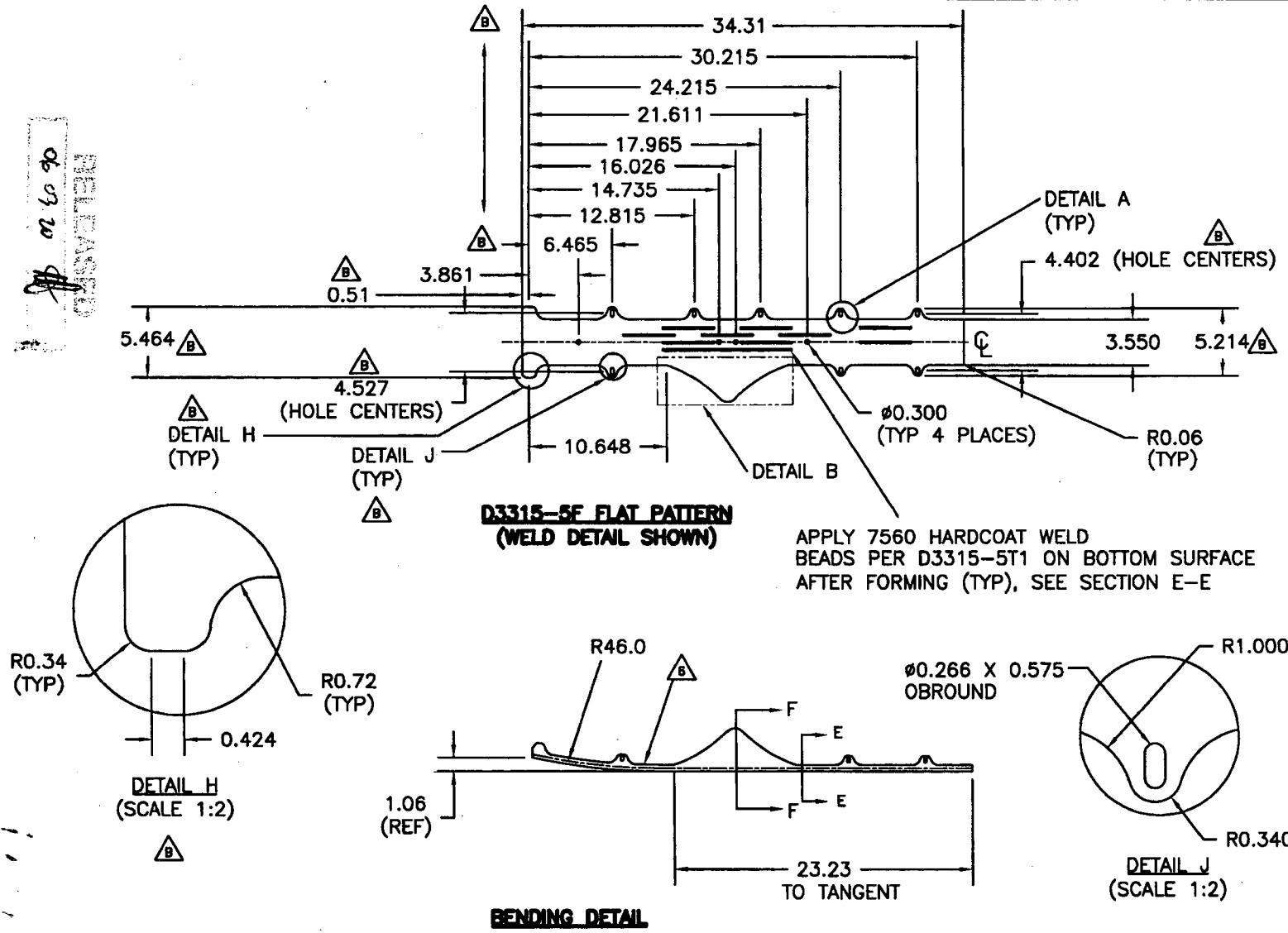
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. B
		DRAWING NO. D3315	
DATE 06.01.31		TITLE WEARPLATE	SCALE 1:16

RELEASED
06.03.20
H

DART

DESIGN <i>P/H</i>	DRAWN BY <i>P/H</i>	DART AEROSPACE LTD		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO.	D3315	REV. B
DATE 06.01.31	TITLE WEARPLATE	SHEET 3 OF 4		SCALE 1:12



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXxxxx, FOR PRODUCT ELIGIBILITY SEE PDA05-17"



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3315	REV. B	SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE	NTS

DETAIL A
(SCALE 1:2)

R0.34
(TYP)

R0.72
(TYP)

\$0.266 X 0.450
OBROUND ▲

DETAIL D
(SCALE 1:2)

- R2.00^{+8.850}_{-8.800}

A diagram showing a stepped profile. The left side has a horizontal dimension of 9.466. The right side has a vertical dimension of 2.831. A label R10.5 (TYP) is at the bottom right.

DETAIL B
(SCALE 1:4)

R2.00^{+0.030}
^{-0.000}

SECTION E-E
(SCALE 1:2)

(-1,-2,-5,-6 ONLY)
.7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH

R1.00 R0.75

**SECTION F-F
(SCALE 1:2)**

0.56
(Typ)

06.03.20 

06.03.20

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DART AEROSPACE LTD	Work Order:	36172
Description: WEAR PLATE	Part Number:	D 3315-5
Inspection Dwg: D 3315-5 Rev: R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .300$	$+.006 -.001$.302	X			
.266	$+.010 -.010$.268	X			
.450	$+.010 -.010$.451	X			
.266	$+.010 -.010$.268	X			
.575	$+.010 -.010$.575	X			
3.550	$+.010 -.010$	3.554	X			
5.214	$+.010 -.010$	5.208	X			
5.464	$+.010 -.010$	5.464	X			
4.527	$+.010 -.010$	4.524	X			
4.402	$+.010 -.010$	4.400	X			
3.861	$+.010 -.010$	3.861	X			
6.465	$+.010 -.010$	6.465				
12.815	$+.010 -.010$	12.815				
14.735	$+.010 -.010$	14.735				
16.026	$+.010 -.010$	16.026				
17.965	$+.010 -.010$	17.965				
21.611	$+.010 -.010$	21.611				
24.215	$+.010 -.010$	24.215				
30.215	$+.010 -.010$	30.215				
34.31	$+.030 -.030$	34.31				

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	07-17-16	Date:	07/12/16	Date:	7/17/16

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

